



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3290-1
Job Sheet 176198



Part No: D3290-1

Job Qty: 10 ea

Part Name: Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 5/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		5/14/18	0.00	0.00	Start Up Waterjet		SC 18/04/20
100	Waterjet	10 pcs		5/14/18	0.00	2.09	Waterjet1		SC 18/04/20
120	QC	10 pcs		5/14/18	0.00	0.00	QC8		38
130	HandFinish	10 pcs		5/14/18	0.00	0.68	HandFinish1		SA 18-04-30
135	QC	10 pcs		5/14/18	0.00	0.00	QC7-2		BE 18-04-30
140	Powdercoat	10 pcs		5/15/18	0.00	0.48	Powdercoat1		BE 18-04-30
150	QC	10 pcs		5/15/18	0.00	0.00	QC3		MAY 0 1 2018
180	Packaging	10 pcs		5/15/18	0.00	0.00	Packaging3-1	SL 432	ED 18-05-02
190	QC21-SA	10 Ea		5/15/18	0.00	0.00	QC21		DAS 21 MAY 0 2 2018

M138760 START 3:30 TEMP: 320° FINISH 3:30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	37.5000 sf (3.75 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	38	250	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches ± 0.030	29.030 28.970	29,000	
2	Window Frame	14.000inches ± 0.030	14.030 13.970	14,000	
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170	0,173	
4	Window Frame	1.500inches ± 0.030	1.530 1.470	1,508	
5	Window Frame	1.110inches ± 0.030	1.140 1.080	1,117	
6	Window Frame	10.100inches ± 0.030	10.130 10.070	10,105	
7	Window Frame	18.500inches ± 0.030	18.530	18,500	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ IQTV Effective : _____ (SI042) Approval

Description Work Order Deviation

Part: D3290-1
 Job No: 176198
 Serial No/Batch: S063388
 Revision:
 Inspector:



DART
 AEROSPACE

Completed By

 Id / Supervisor
 al Verification

Coordinator approval

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 CANADA
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 www.dartaerospace.com

Date: 04/20/18

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Fo ☐	ned Wrong
Design ☐	Operator ☐	Bending ☐	e Dimensions
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐	nder tolerance
Equip/Tooling ☐	Supplier ☐	Cracks ☐	...correct
Handling/Pre ☐	Training ☐	Crimp/Kink/Rippie/wave ☐	Part Lost/Missing
Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved
Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

			18.470	
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053	0,062
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970	3,002
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470	4,509
11	Window Frame	0.257inches + 0.006 - 0.001	0.263 0.256	0,260
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580	13,613

Plex 4/18/18 1:16 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
						Completed By															
						Lead hand / Supervisor Approval Verification															
QC / QA Coordinator Approval																					
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					